



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

RB 92700-10400-041-14-PO

Job Sheet 185640



Part No: RB 92700-10400-041-14-PO **Job Qty:** 3 ea

Part Name: Roll Stop Gauge



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 10/31/18

Job Tracking No:

Due Date: 12/14/18

Created By: Patrick Lussier

Type: Stock

Description:

Note: DWG RB 92700-10400-041 Rev.A. IPP Rev. A 18.10.29 New issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Purchasing	3 pcs	12/14/18	12/14/18	0.00	0.00	Purchasing		
110	Packaging	3 pcs	12/14/18	12/14/18	0.00	0.00	Packaging2		
120	QC	3 pcs	12/14/18	12/14/18	0.00	0.00	QC6		DEC 21 2018 68
130	Small Fab	3 pcs	12/14/18	12/14/18	0.00	0.30	Small Fab-2		9-89
140	QC	3 pcs	12/14/18	12/14/18	0.00	0.00	QC5		
150	Packaging	3 pcs	12/14/18	12/14/18	0.00	0.00	Packaging3		
160	QC21-SA	3 Ea	12/14/18	12/14/18	0.00	0.00	QC21		

Part Op 100 - Issue P/O: 041341 MANUFACTURE RB 92700-10400-041-14 AS PER DWG Supplier: ARROW TECH
Descriptions: MACHINE WORKS -Certificate of conformity is required

130 - Re-identify as required.

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
RB 92700-10400-041-14P	Roll Stop Gauge	3 (1 ea)	100-Purchasing	5139638

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Purchasing	RB 92700-10400-041-14P	3	0	0

Part Specifications

Specifications could not be found.

Plex 10/31/18 9:22 AM dart.Lussier.Patrick



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Container No: S139639



Part: RB 92700-10400-041-14

Job No: 185640

Serial No/Batch: S139639

Revision: A

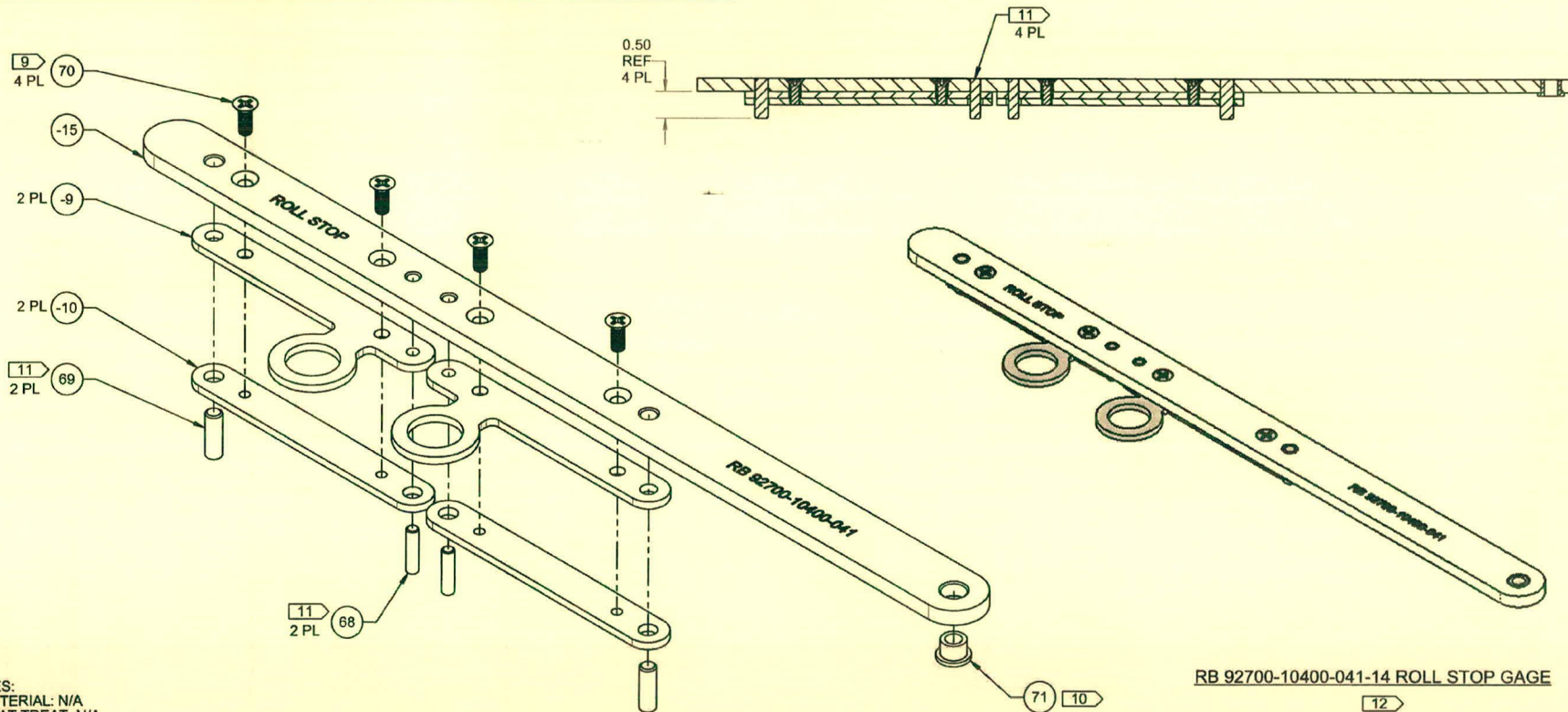
Inspector:

Exp Date:

Instructions:

Date: 12/20/18

ITEM #	QTY	PART #	PART TITLE
-9	2	RB 92700-10400-041-9	RIG GAGE PLATE (SPARES)
-10	2	RB 92700-10400-041-10	TOP PLATE
-15	1	RB 92700-10400-041-15	BASE PLATE
68	2	McMaster#97395A471 OR EQUIV	SS DOWEL PIN 3/16" DIA. x 3/4" LG.
69	2	McMaster#97395A485 OR EQUIV	SS DOWEL PIN 1/4" DIA. x 3/4" LG.
70	4	McMaster#91500A829 OR EQUIV	SS PHILLIPS FLAT HEAD SCREW #10-32 x 1/2" LG.
71	1	NAS77A4-025	FLANGE BUSHING



NOTES:

- 1) MATERIAL: N/A
- 2) HEAT TREAT: N/A
- 3) FINISH: N/A

- 4) TOLERANCES: X.X = +/- 0.1" / +/- 1"
- X.XX = +/- 0.01" / +/- 0.5"
- X.XXX = +/- 0.005" / +/- 0.1"
- X.XXXX = +/- 0.0005" / +/- 0.05"

PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/- 0.005"

- 5) UNITS: INCHES UNLESS OTHERWISE NOTED

- 6) BREAK SHARP EDGES: N/A

- 7) IDENTIFICATION: N/A

- 8) ASSEMBLE AS SHOWN

- 9) INSTALL ITEMS 70 HAND TIGHT

- 10) APPLY LOCTITE 620 OR EQUIVALENT ON MATING SURFACES THEN PRESS FIT ITEM 71 WITH ITEM -15 AND REMOVE EXCESS

- 11) APPLY LOCTITE 620 OR EQUIVALENT ON MATING SURFACES THEN PRESS FIT ITEMS 68 AND 69 FLUSH TO SURFACE OF ITEM -15 AND REMOVE EXCESS

- 12) THE TOOL ASSY MUST BE PACKAGED WITH A DESICCANT BAG INTO A TIGHT FITTING SEALED PLASTIC BAG

DESIGN VM
DRAWN VM
CHECKED ML
MFG. APPR. DP
APPROVED VV

DATE 9/19/2018

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

TOOL PART #
RB 92700-10400-041

TITLE
RIGGING KIT

REV. A

SHEET 16 OF 62

SCALE

NTS

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ARROW TECH MACHINE WORKS

Certificate of Conformance

Your Purchase Order No: 041341 ✓

Dated: 12/14/2018 ✓

Our Order / Job No: 041341-29AWT

Order Qty: 3 ✓

Part Name: ROLL STOP GAGE

Part Number: RB 92700-10400-041-14 ✓

Lot Size: N/A

Ship Date: 12/14/2018

We certify that these parts shipped to you are of domestic or international manufacture and conform to all requirements of the Purchase Order. These parts have been manufactured and inspected in accordance with all required specifications, instructions and drawings. Any applicable specifications are listed below:

Drawing Number: RB 92700-10400-041-14

Rev: A

Material Size and Type: -9/CLEAR POLYCARBONAT; -10/ 303 SS;-15/6060-T6 ALUM.;

Material Specifications: POLY.: UL 94V2, UL 972; SS: AMS 5640, ASTM A314, ASTM A582;
ALUM: ASTM B209

Heat Treatment: N/A

Plating/Finish: CLEAR ANODIZE: MIL-A-8625F TYPE 2 CLASS 1

Mercury Contamination: The material used to process this order has not come in contact with mercury or mercury bearing instruments.

Date: 12/17/18

Signed: 

DAS
68
9-89

PHGE Machine Works LLC dba Arrow Tech Machine Works
29751 E. Enid Rd. Unit C Eugene, Oregon 97402
Main: (541) 780-6938 | Fax: (458) 215-4938
www.atechmachineworks.com

83
62-1



**PHGE Machineworks dba
Arrowtech Machineworks**
29751 E Enid Rd. Unit C
Eugene, Oregon 97402
Phone: (541) 780-6938
Fax: (458) 215-4938

Packing Slip

NO. 356

PAGE 1 OF 2

Date: 12/14/2018 ✓
PO Ref: 041341 ✓
Ship via: Fedex Priority

Bill To:
Dart Aerospace
1270 Aberdeen St. Hawkesbury, ON
CANADA K6A 1K7

Ship To:
Dart Aerospace
1271 Aberdeen St. Hawkesbury, ON
CANADA K6A 1K8

Qty	Item	Part No.
3 ✓	SEAL INSTALLATION TOOL	RB 92700-10300-041 - 1
3 ✓	PLATE ASSEMBLY	RB 92700-10303-041 - 4
3 ✓	WRENCH ASSEMBLY	RB 92700-10303-041 - 6
3 ✓	TGB & IGB SEAL INSTALLER ASSEMBLY	RB 92700-10305-041 - 4
2 ✓	TR NUT WRENCH	RB 92700-10307-041 ✓
3 ✓	TAIL BLADE WRENCH (DE-ICE) WELDMENT	RB 92700-10309-042 ✓
3 ✓	TORQUE REACTOR	RB 92700-10314-101 ✓
3 ✓	SIGHT GUAGE REMOVAL TOOL	RB 92700-10328-041 ✓
3 ✓	ENGINE DRIVE SHAFT REMOVAL TOOL ASS	RB 92700-10333-041 ✓
3 ✓	BEARING SPANNER WRENCH	RB 92700-10340-101 ✓
3 ✓	SEAL REMOVAL ASSEMBLY	RB 92700-10350-041 - 5
3 ✓	BEARING ALIGNMENT TOOL	RB 92700-10356-041 ✓
3 ✓	TORQUE ADAPTER	RB 92700-10750-101 ✓
3 ✓	INPUT MODULE WRENCH	RB 92700-10750-102 ✓
3 ✓	RIG PLATE SCREW	RB 92700-10400-041-6 ✓
3 ✓	PIT STOP GUAGE	RB 92700-10400-041-7 ✓
3 ✓	RIG GUAGE PLATE (SPARES)	RB 92700-10400-041-9 ✓

Received by: _____

Packaged by: _____

Checked by: _____

Thank You



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CANADA K6A 1K8

Qty	Item	Part No.
3	TRS LEFT STOP GUAGE	RB 92700-10400-041-11
3	RH MID GUAGE	RB 92700-10400-041-12
3	TR MID BLOCK	RB 92700-10400-041-13
3	ROLL STOP GUAGE	RB 92700-10400-041-14
3	COLL STOP GUAGE	RB 92700-10400-041-16
3	LIMITER GUAGE	RB 92700-10400-041-18
3	LH MID GUAGE	RB 92700-10400-041-20
3	FWD MID GUAGE	RB 92700-10400-041-22
3	RH MID GUAGE	RB 92700-10400-041-24
3	MIX PIN P / C / R	RB 92700-10400-041-26
3	MIX PIN YAW	RB 92700-10400-041-28
153	RIG PIN ASSEMBLY	RB 92700-10400-041-30
3	BOOST COL LOW	RB 92700-10400-041-33
3	3.5" PIN ASSEMBLY	RB 92700-10400-041-36
3	9" PIN ASSEMBLY	RB 92700-10400-041-39
3	16" PIN ASSEMBLY	RB 92700-10400-041-41
3	COCKPIT - RIG PINS <i>Missing CFC</i>	RB 92700-10400-041-43

Received by:

Packaged by: *ADD*

Checked by: *Q.F.*

Thank You



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CANADA K6A 1K7

Ship To:
Dart Aerospace
1271 Aberdeen St. Hawkesbury, ON
CANADA K6A 1K8

Qty	Item	Part No.
3 ✓	5" PIN ASSEMBLY	RB 92700-10400-041-45 ✓
3 12 ✓	BOOST MID PIN	RB 92700-10400-041-49 ✓
3 ✓	ROTOR HEAD - CROSS BAR	RB 92700-10400-041-52 ✓
3 ✓	CYCLIC - RIG BLOCK ASSEMBLY	RB 92700-10400-041-63 ✓
3 ✓	ROTOR HEAD - RIG PLATE	RB 92700-10400-041-64 ✓

Received by: _____
Packaged by: AMP
Checked by: SP

Thank You



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER

PO041341

Items													
Line Item	Job	Part	Supplier Part No	Item No	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (USD)	Extended Price
24	185633	RB 92700-10400-041-7P			Pitch Stop Gauge REV A	Firmed	-	12/21/18	3 Ea	0 Ea	3 Ea	\$213.84/Ea	\$641.52
Line Item Note SUB ASSY FOR TOP LEVEL RB 92700-10400-041													
25	185634	RB 92700-10400-041-9P			Rig Gauge Plate (Spares) REV A	Firmed	-	12/21/18	3 Ea	0 Ea	3 Ea	\$213.84/Ea	\$641.52
Line Item Note SUB ASSY FOR TOP LEVEL RB 92700-10400-041													
26	185636	RB 92700-10400-041-11P			TRS Left Stop Gauge REV A	Firmed	-	12/21/18	3 Ea	0 Ea	3 Ea	\$213.84/Ea	\$641.52
Line Item Note SUB ASSY FOR TOP LEVEL RB 92700-10400-041													
27	185638	RB 92700-10400-041-12P			RH Mid Gauge REV A	Firmed	-	12/21/18	3 Ea	0 Ea	3 Ea	\$213.84/Ea	\$641.52
Line Item Note SUB ASSY FOR TOP LEVEL RB 92700-10400-041													
28	185639	RB 92700-10400-041-13P			TR Mid Block REV A	Firmed	-	12/21/18	3 Ea	0 Ea	3 Ea	\$213.84/Ea	\$641.52
Line Item Note SUB ASSY FOR TOP LEVEL RB 92700-10400-041													
29	185640	RB 92700-10400-041-14P			Roll Stop Gauge REV A	Firmed	-	12/21/18	3 Ea	0 Ea	3 Ea	\$213.84/Ea	\$641.52
Line Item Note SUB ASSY FOR TOP LEVEL RB 92700-10400-041													
30	185641	RB 92700-10400-041-16P			Coll Stop Gauge REV A	Firmed	-	12/21/18	3 Ea	0 Ea	3 Ea	\$213.84/Ea	\$641.52
Line Item Note SUB ASSY FOR TOP LEVEL RB 92700-10400-041													
31	185642	RB 92700-10400-041-18P			Limiter Gauge REV A	Firmed	-	12/21/18	3 Ea	0 Ea	3 Ea	\$213.84/Ea	\$641.52
Line Item Note SUB ASSY FOR TOP LEVEL RB 92700-10400-041													
32	185643	RB 92700-10400-041-20P			LH Mid Gauge REV A	Firmed	-	12/21/18	3 Ea	0 Ea	3 Ea	\$213.84/Ea	\$641.52

Plex 12/17/18 2:31 PM dart.Lussier.Patrick

